

Work Order ID 54875

January 04, 2010 1:21:54 PM



Page 1

Item ID: D3684-047

Accept



Setup Start



Revision ID:

Item Name: FWD LEG ASS'Y

Stop



Start Date: 1/5/2010 Start Qty: 4.00

Required Date: 1/18/2010 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *12-01-04*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3684

Rev C

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

SB 10/01/22

(6)

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Use anti-seize compound Tectly 502c Class 1,Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684

2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684

**Ensure holes for AN3C Bolts are free of sealant.
Torque Fastners as per Dwg D3684

SB 10/01/25

6

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Set Up/
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Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

29 51010125

(X6)

Quality Control

130

Identify as per dwg & Stock Location: 29

0.00



Packaging

Memo

0.00

Packaging

10-1-25 (6x) SP

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/26 JF
CMF 10-1-25

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Picklist Print

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Work Order ID: 54875

Parent Item: D3684-047

Parent Item Name: FWD LEG ASS'Y


Start Date: 1/5/2010

Required Date: 1/18/2010

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C12A  Bolts		Purchased	No			110	Each	350.0000	8.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

350

112314

350

D3688-1

Manufactured

No

110

Each

2.0000

4.0000

STUD

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2

50932

2

D3689-1

Manufactured

No

110

Each

21.0000

4.0000

SLEEVE

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2

46051

2

Main Warehouse

ST125

19

50745

19

12 80 10/6/12

6 80 10/6/12

6 80 10/6/12

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Parent Item Name: FWD LEG ASS'Y





Comments:

Start Date: 1/5/2010

Required Date: 1/18/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3691-1 		Manufactured	No			110	Each	0.0000	4.0000	<u>6</u>		
STUD								<u>54859</u>				
D3692-1 		Manufactured	No			110	Each	642.0000	16.0000			
SPACER												

8/10/01/22

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	55	
44827	8	
45672	14	
50325	33	
Main Warehouse		
ST127	587	
50736	179	
51467	408	

8/10/01/22

24

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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Start Date: 1/5/2010

Required Date: 1/18/2010

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3693-1		Manufactured	No			110	Each	73.0000	4.0000			
---------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Rod End Bearing

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST	5	
----	---	--

45723	5	
-------	---	--

Main Warehouse

ST127	68	
-------	----	--

50733	7	
-------	---	--

50734	61	
-------	----	--

MS21043-3		Purchased	No			110	Each	4,542.000	8.0000			
-----------	--	-----------	----	--	--	-----	------	-----------	--------	--	--	--



Nut

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

OFFSHORE

FG	80	
----	----	--

103691	80	
--------	----	--

Main Warehouse

ST	4462	
----	------	--

111819	70	
--------	----	--

112243	29	
--------	----	--

112314	4363	
--------	------	--

Sp 10/01/22

6

Sp 10/01/22

12

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Required Date: 1/18/2010

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS509-12C 		Purchased	No			110	Each	126.0000	4.0000			
Nuts												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	126	
106993	7	
110844	10	
112453	109	

SS 10/01/22
6

NAS509L12C 		Purchased	No			110	Each	85.0000	4.0000			
Nuts												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	85	
106993	2	
112314	73	
112828	10	

SS 10/01/22
6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

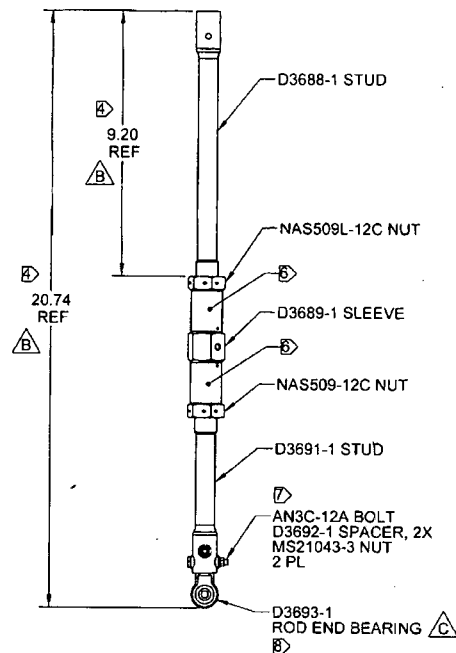
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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ITEM	QTY -047	PART NUMBER	DESCRIPTION
1	X	D3684-047	FWD LEG ASSEMBLY
2	1	D3688-1	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



D3684-047 FWD LEG ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-1 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.10 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3684	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
DATE	08.12.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD	

RELEASED
09/01/12

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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